

Date: Wednesday, 3/21/2007 3:49:41 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR ASSEMBLY					
Job Number	: 31432								
Estimate Number	: 10711								
P.O. Number	: N/A			Part Number	: D32131				
This Issue	: 3/21/2007		S.O. No.	: N/A					
Prsht Rev.	: NC			Drawing Number	: D3213 REV A				
First Issue	: N/A		Type	: SMALL /MED FAB					
Previous Run	: 30656			Project Number	: N/A				
Written By	: <i>JL</i>			Drawing Revision	: A				
Checked & Approved By	: <i>JL</i>			Material	: N/A				
Comment	: Est Rev:A		New Issue	05-11-17 JLM		Due Date	: 4/10/2007		
	Est Rev:B		Now on Waterjet	07-02-13 JLM		Qty:	10	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
		 <i>M 07 04 16</i>
		 <i>(10)</i>
2.0	WATER JET	FLOW WATER JET
		 <i>M 07 04 18</i>
		 <i>(10)</i>
	Comment: FLOW WATER JET	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <i>M 07 04 18</i>
		 <i>(10)</i>
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		 <i>M 07 04 19</i>
		 <i>(10)</i>
	Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <i>M 07 04 19</i>
		 <i>(10)</i>
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Deburr	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		 <i>FF 07-04-19</i>
		 <i>(10)</i>
	Comment: HAND FINISHING RESOURCE #1	
	Chemical Conversion Coat as per QSI 005 4.1	
		 <i>07/04/20</i>
		 <i>(10)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 31432

Part Number: D32131

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10X

M.F.

07/04/20

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 07/04/20

10

9.0 QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

SD 07/04/20

Job Completion



J. 07/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

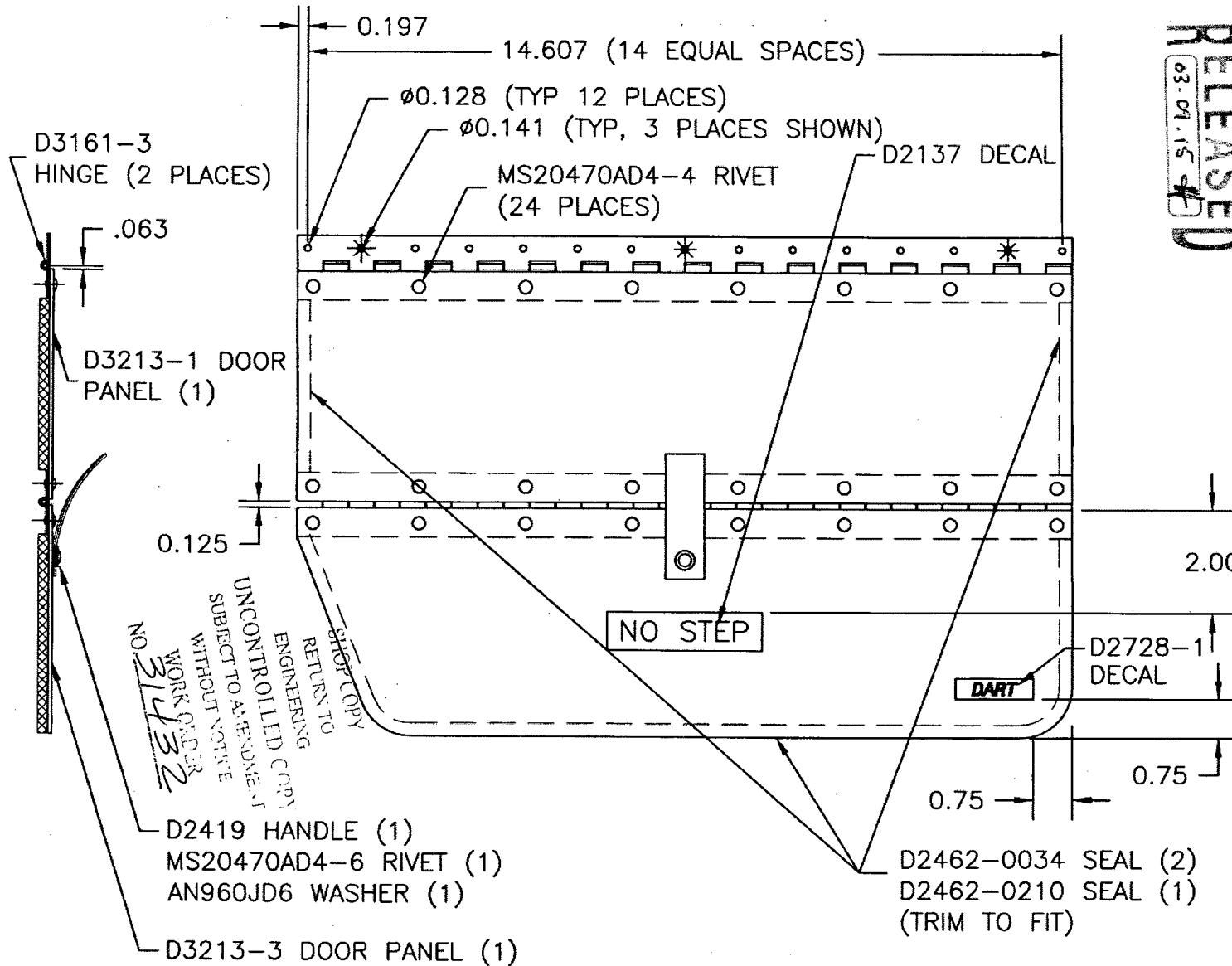
DART AEROSPACE LTD	Work Order:	31432
Description: Door Panel	Part Number:	D3213-1
Inspection Dwg: D3213 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>M. M. M.</u>	Audited by:	<u>M</u>	Prototype Approval:	N/A
Date:	07.04.19	Date:	07/04/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF 	



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.03

DART

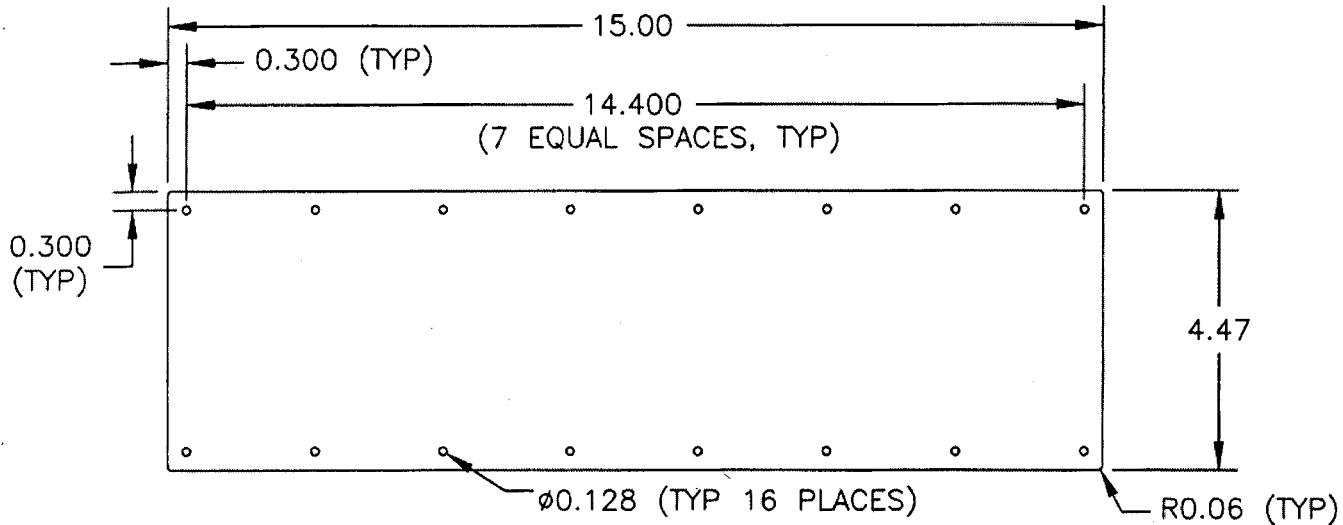
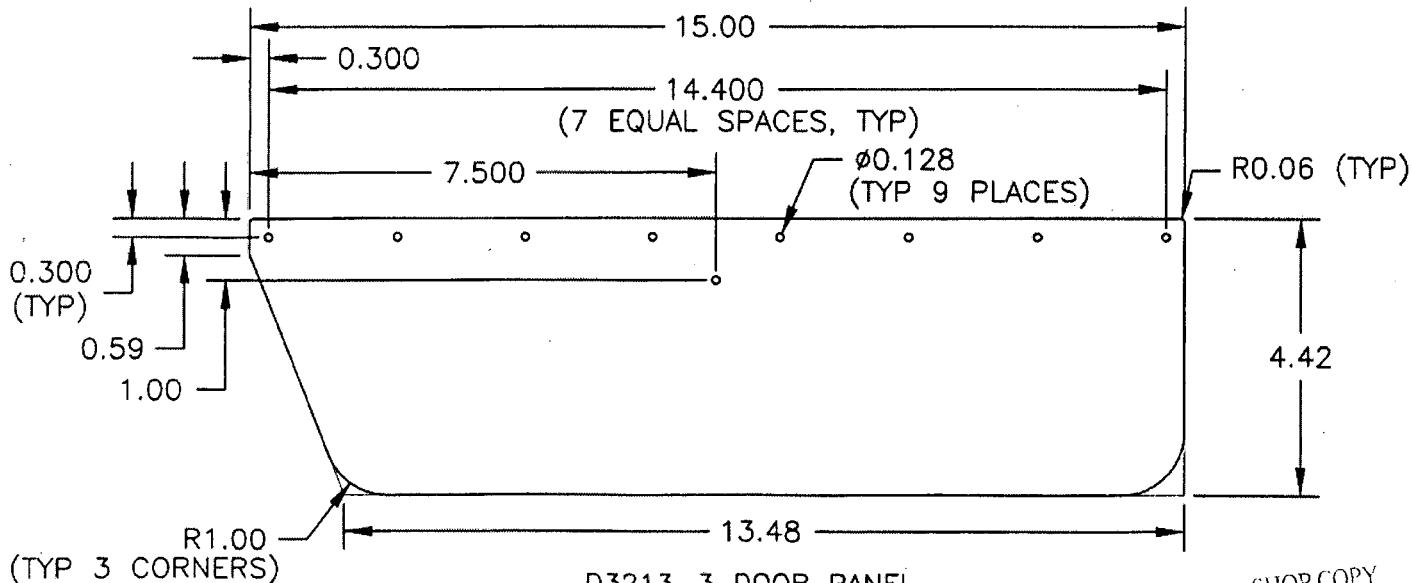
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
A	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
✓	✓	D3213
DATE		TITLE
03.09.03		DOOR ASSEMBLY
A	03.09.03	NEW ISSUE

REV. A
1 OF 2
SCALE
1:3

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3213
DATE	03.09.03	REV. A 2 OF 2 SCALE 1:3 TITLE DOOR ASSEMBLY

D3213-1 DOOR PANELD3213-3 DOOR PANELD3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
 03.09.03
 ISSUE 1
 AMENDMENT
 WITHOUT NOTICE

 WORK ORDER
 NO 31432

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